

*Push Need July 14<sup>th</sup> 12:00*  
Dart Aerospace Ltd.

Date: Tuesday, 04/07/2006 11:46:55 AM  
User: Linda Lacelle

### Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FITTING	
Job Number	: 27758		Part Number	: D32161	
Estimate Number	: 10869		Drawing Number	: D3216 REV A	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 04/07/2006 S.O. No. : N/A		Drawing Revision	: A	
Prsh Rev.	: NC		Material	: N/A	
First Issue	: 28/06/2006 Type : PURCHASED PARTS		Due Date	: 12/07/2006	
Previous Run	: 25881		Qty:	50	Um: Each
Written By	<i>See Comment Below</i>				
Checked & Approved By	<i>h</i>				
Comment	: Est: A 03.10.28 New Issue KJ/RF				

#### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S11GA	304/316 .125 Sheet <i>101463</i>
		Comment: Qty.: 0.0288 sf(s)/Unit Total : 1.4400 sf(s) 304/316 .125 Sheet <i>M 06/07/07</i>
2.0	WATER JET	FLOW WATER JET <i>M 06/07/07 (50)</i>
		Comment: FLOW WATER JET <i>M 06/07/07 (50)</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE <i>M 06/07/07 (50)</i>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>M 06/07/07 (50)</i>
4.0	<i>QC B 2</i>	DIMENSIONAL CHECK <i>Joe-07-03 (50)</i>
		Comment: DIMENSIONAL CHECK <i>Joe-07-03 (50)</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 <i>MF- 06/07/11 (50)</i>
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary. Tumble until parts have a polished finish. <i>MF 06/07/12 (50)</i>
6.0	QC5	INSPECT WORK TO CURRENT STEP <i>SB 06/07/12 (50)</i>
		Comment: INSPECT WORK TO CURRENT STEP <i>SB 06/07/12 (50)</i>

Date: Tuesday, 04/07/2006 11:46:56 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 27758

Part Number: D32161

Job Number:



Seq. #:	Machine Or Operation:	Description :
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7.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:        STY16

4/7/15 50

8.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

4/6/17

Job Completion



4/6/15

Date: Wednesday, 6/28/2006 4:18:45 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FITTING		
Job Number	: 27758					
Estimate Number	: 10869					
P.O. Number	:			Part Number	: D32161	
This Issue	: 6/28/2006		S.O. No.	: D3216 REV A		
Prsh Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	: PURCHASED PARTS		
Previous Run	: 25881			Drawing Revision	: A	
Written By	:			Material	:	
Checked & Approved By	:			Due Date	: 7/12/2006	
Comment	: Est: A 03.10.28 New Issue KJ/RF			Qty:	50	Um: Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O:

Material:  
(m30450125)  
(.0288SF)

M 06 07 06

Email or Ship DXF file to vendor

Laser Cut D3216-1 Fitting as per Dwg D3216

Batch: M 6789

Material release note is required

M 101463

2.0 D3216 IF



Waterjet

Fitting



Comment: Qty: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)

Fitting

Prog Rev. A

Prog Rev. A

M 06 07 07 (50)

3.0 PACKAGING 1



QC2

PACKAGING RESOURCE #1



M 06 07 01

Comment: PACKAGING RESOURCE #1

Recieve &amp; Inspect for Transit Damage

Ensure Material Release Note is attached

M 06 07 01 (60)

4.0 QC8



DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5.0 SMALL FAB 1



SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Deburr if necessary.

Tumble until parts have a polished finish.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06-07-02	4.0	QC 8 for second check. Permanent change <i>2</i>					<i>06-07-02</i>

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Wednesday, 6/28/2006 4:18:46 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 27758

Part Number: D32161

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

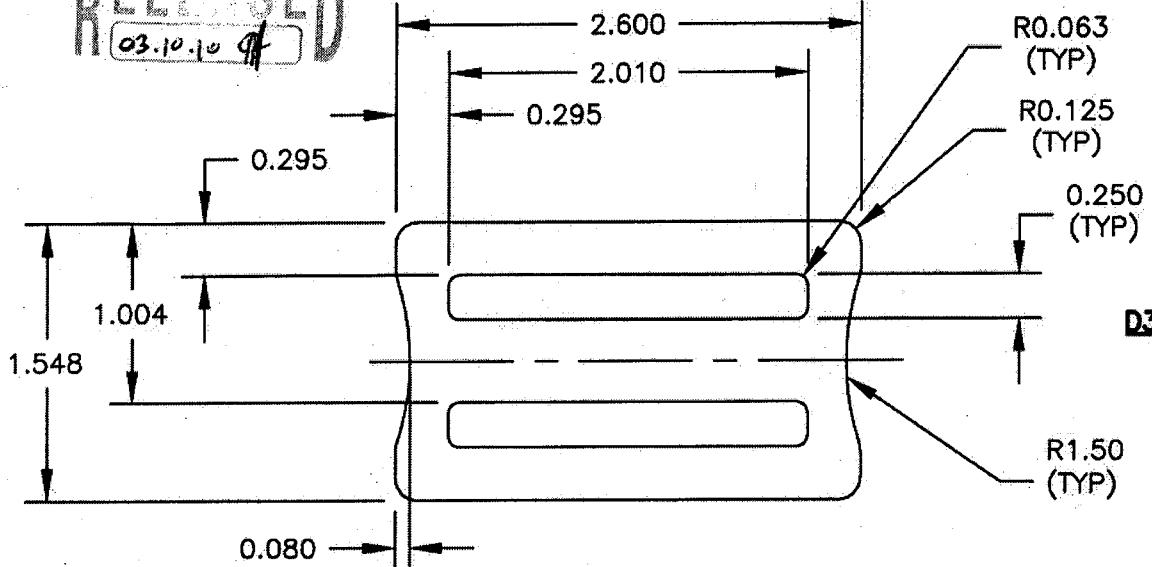
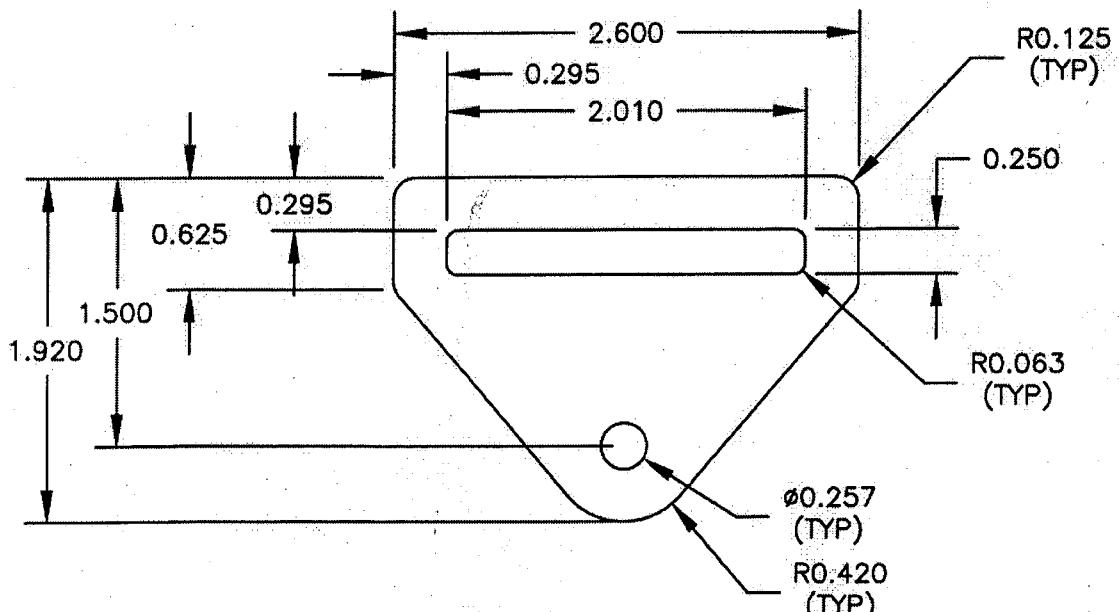
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**DART**COPY ISSUED  
ON

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3216	SHEET 1 OF 1
DATE	TITLE	SCALE	
03.09.26	FITTING	1:1	
A	03.09.26	NEW ISSUE	

**RELEASED**  
03.10.10 off**D3216-1 FITTING****D3216-3 FITTING**

SHOP COPY  
RETURN TO  
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 27758

**D3216-1/-3 FITTING**

- 1) MATERIAL: AISI 304/316 PLATE, 0.125 THICK (REF DART SPEC. M304S110)
- 2) FINISH: MOLECRO POLISH
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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DART AEROSPACE LTD	Work Order:	21758
Description:	Part Number:	3216-1
Inspection Dwg: , Rev:		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article X Prototype

Measured by:	<u>MM</u>
Date:	16/07/08

<b>Audited by:</b>	
<b>Date:</b>	06.07.07

<b>Prototype Approval:</b>	—
<b>Date:</b>	—

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	